

Work Order ID 75293

October-20-11 9:57:18 AM

75293

Page 1

Item ID: D3915-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Light Lid Assembly, Long Basket
 Start Date: 20/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 08/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M L J Date: 11/10/20 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr | |
|----------|--------------|--|
| D3915 | C | |

100 Weld per dwg A/R Aluminum rod Batch: _____ 0.00
100 Large Fab m120854 1X Pl 12.7.30
 Large Fab Memo 0.00
 Large Fab 1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.
 ****DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME****
 2- weld hinge, label plate and Mounting plates as per dwg D3915

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110 QC Memo 0.00
 Quality Control 1 0 12/07/31 DAS 18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 *120* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | 264131 | | | | | |
| 130 *130* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo ***ENSURE TO RINSE CAREFULLY ACID AND ALODINE*** | 0.00 0.00 | | | | | | | |
| 140 *140* Large Fab Large Fab | Weld per dwg A/R Aluminum rod Batch: _____ Memo 1- weld (4) corners | 0.00 0.00 | | | | | | | |

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| 150 | QC9- Inspect visual per QSI004- Fusion Welds | 0.00 | | | | 1 | 0 | 12/08/01 | DAS 18 9-8 |
| *150* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 155 | QC6- Inspect dimensions to drawing | 0.00 | | | | | | | |
| *155* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| | ***inspect fit of lid with base*** | | | | | | | | |
| 157 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *157* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | 1- realodine corners ***do not acid etch*** | | | | | | | | |

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|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| Powdercoat | Memo | 0.00 | | | | | | | |
| Powder Coating | 1- touch up corner with alodine only 2- Plug holes prior to | | | | | | | | |
| | 1ST COAT: START TIME: <u>8:26:55</u> OVEN TEMPERATURE: <u>320°F</u> FINISH TIME: <u>8:25</u> M 121841 ***** 2nd coat if necessary***** | | | | | | | | |
| | 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ | | | | | | | | |
| 170 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

1 ~~2~~ ~~20~~ 12/08/02

1x ~~1~~ M 12/08/02

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| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 180 | Assemble as per dwg | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | ✓ 1- Install webbing as per dwg | | | | | | | | |
| | ✓ 2- Install placard and label as per dwg | | | | | | | | |
| 190 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *190* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 200 | Identify as per dwg & Stock Location: <u>W/O</u> | 0.00 | | | | | | | |
| *200* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

DAS
16
9-82

D 4272-014 / B75292

ix d Muloslor

ix d Muloslor

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NOTE: Date & initial all entries

Work Order ID 75293***75293***

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Item ID: D3915-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Light Lid Assembly, Long Basket

Stop ***NS2***

Start Date: 20/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 08/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00


210

QC

Memo

0.00

Quality Control

12/8/10 

P1208-9

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 75293

75293

Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2957

Manufactured

No

100

Each

9.0000

4

4

**

D2957

Mounting Plate

Location

Loc Qty

Loc Code

WA

9

71221

9

D3915-1

Manufactured

No

100

Each

4.0000

2

2

**

D3915-1

Rib

Location

Loc Qty

Loc Code

WA

4

63663

0

65321

0

73204

4

D4016-5

Manufactured

No

100

Each

9.0000

3

3

**

D4016-5

Hinge Half, Light Lid

Location

Loc Qty

Loc Code

WA

6

74468

6

WA005

3

66335

3

PC 12.7.30

B87753 → 4

PC 12.7.30

B83844 → (2)

PC 12.7.30

B87050 → (3)

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Picklist Print

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Work Order ID: 75293

75293

Parent Item: D3915-041

D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4019-3 Manufactured No

100 Each

5.0000

3 3

D4019-3

Rib

**

Location

Loc Qty

Loc Code

WA

5

63667

0

68605

5

386449 → ③

D4035-045 Manufactured No

100 Each

1.0000

1 1

D4035-045

Lid Rib Assembly, Fwd (Light)

**

Location

Loc Qty

Loc Code

WA006

1

68545

1

384688 → ①

D4035-047 Manufactured No

100 Each

2.0000

1 1

D4035-047

Lid Rib Assembly, Aft (Light)

**

Location

Loc Qty

Loc Code

WA

2

63669

0

71225

2

385936 → ①

D4056-1 Manufactured No

100 Each

3.0000

1 1

D4056-1

Label Plate

**

Location

Loc Qty

Loc Code

WA

3

70338

3

385016 → ①

D2728-1 Manufactured No

180 Each

0.0000

1 1

D2728-1

Dart Logo label

**

October-20-11 9:57:23 AM

Shop Packet Print

Page 2

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Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

75293***D3915-041***

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

D4029-041 Manufactured No

180 Each 3.0000 1 1

D4029-041

Webbing (Long Basket)

**

84412

LocationLoc QtyLoc Code

st503

3

69499

3

MS20600-AD4W3

Purchased No

180 Each 1,415.000 34 34

MS20600-AD4W3

Cherry Rivets

**

M122101

LocationLoc QtyLoc Code

GA

882

118626

882

ST321

400

111636

48

117505

317

117601

35

WA018

133

107939

133

NAS1149DN416J

Purchased No

180 Each 215.0000 34 34

NAS1149DN416.I

Washer

**

M122101 6/14/02

LocationLoc QtyLoc Code

ST298

215

114348

11

114597

119

13910

85

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Shop Packet Print

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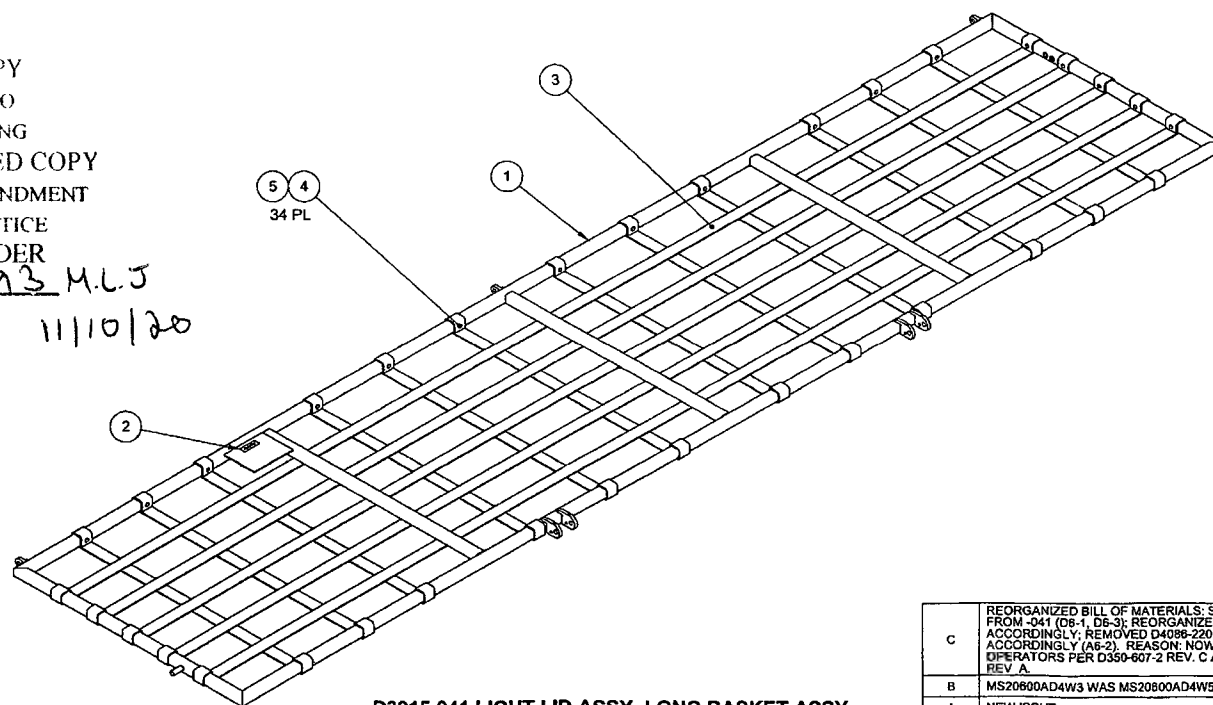
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NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|---------------|----------------------------------|
| | X | D3915-041 | LIGHT LID ASSY, LONG BASKET ASSY |
| 1 | 1 | D3915-101 | BASKET LID WELDMENT ASSY |
| 2 | 1 | D2728-1 | DART LOGO LABEL |
| 3 | 1 | D4029-041 | WEBBING (LONG BASKET) |
| 4 | 34 | MS20600AD4W3 | BLIND RIVET |
| 5 | 34 | NAS1149DN416J | WASHER |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 35293 M.L.J
11/10/20



D3915-041 LIGHT LID ASSY, LONG BASKET ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.91 lbs

RELEASED
10-08-12
ECN 10-546

| | | | |
|--|---|-----|----------|
| C | REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D6-1, D6-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4086-220, UPDATED VIEW E ACCORDINGLY (A6-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A. | MB | 10.08.05 |
| B | MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2) | JPH | 10.04.06 |
| A | NEW ISSUE | JPH | 10.03.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | ALS | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.08.05 | | |
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3915 REV. C SHEET 1 OF 4 TITLE LIGHT LID ASSY-LONG BASKET NTS SCALE COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | | |

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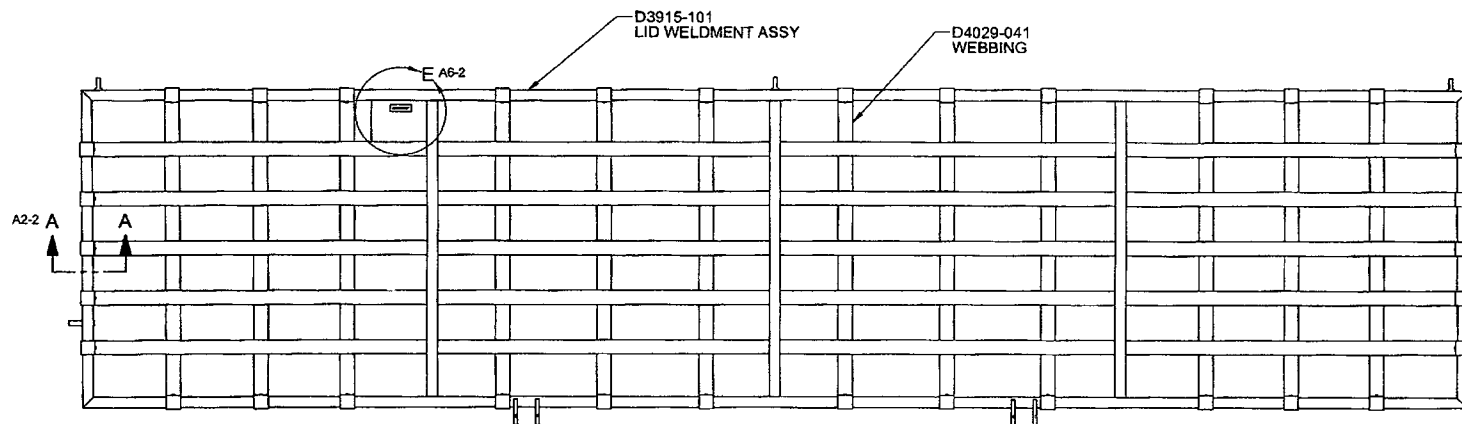
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

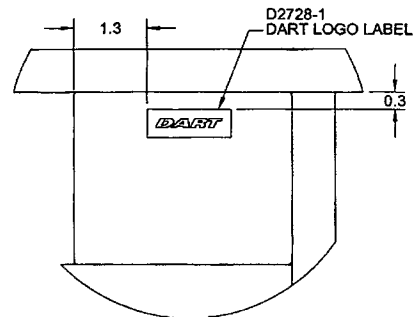
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

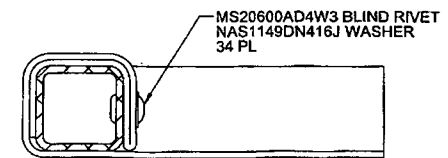
75293



D3915-041 LIGHT LID ASSY, LONG BASKET



VIEW E D6-2



SECTION A-A C8-2

RELEASED
10.08.12

| | | | |
|------------|----------|--|--------------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | A | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | SC | DRAWING NO. | REV. C |
| MFG. APPR. | SC | D3915 | SHEET 2 OF 4 |
| APPROVED | SC | TITLE | SCALE |
| DE APPR. | SC | LIGHT LID ASSY-LONG BASKET | NTS |
| DATE | 10.08.05 | <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

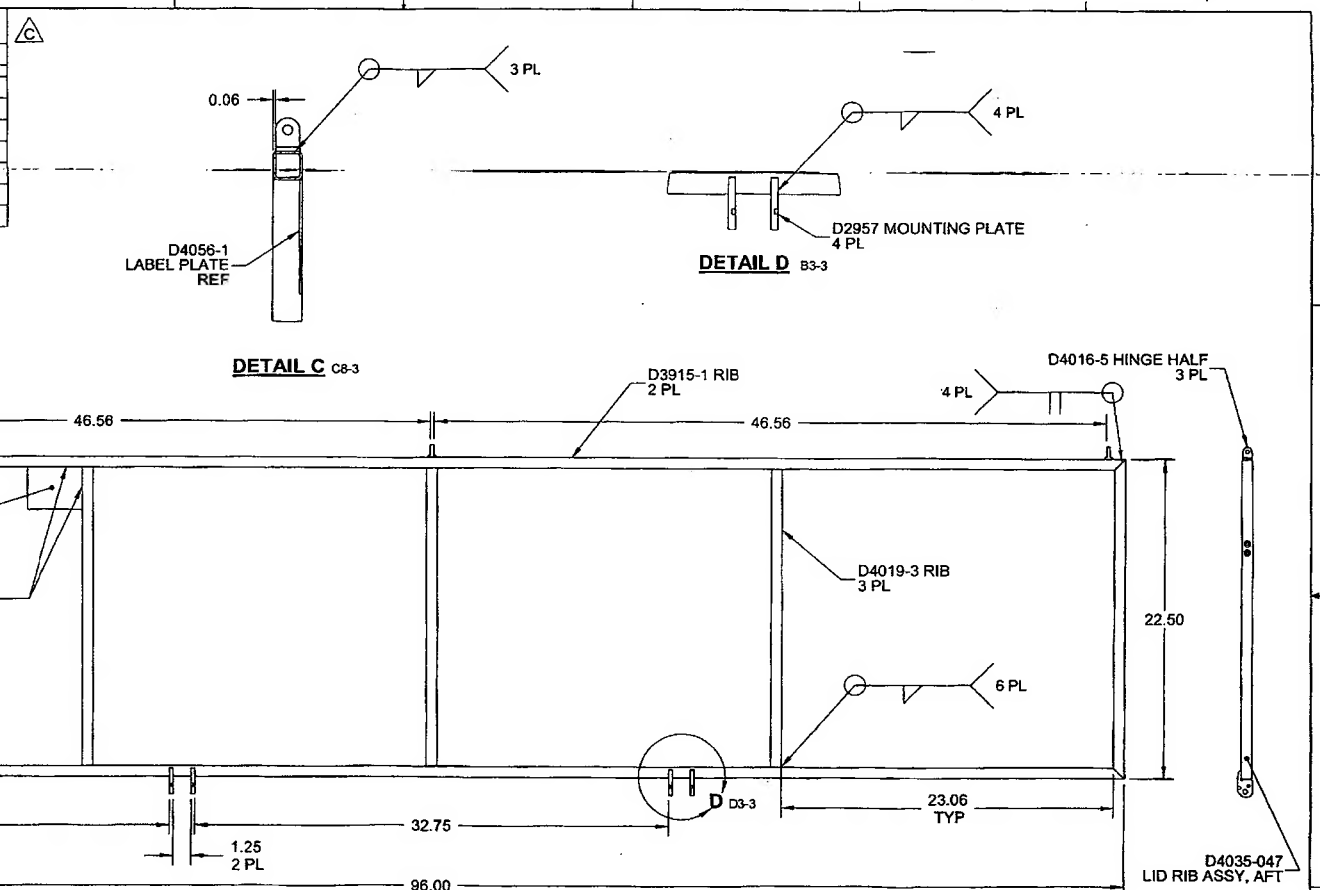
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

75293

| ITEM | QTY -101 | P/N | DESCRIPTION |
|------|-------------|-----------|----------------------------------|
| | X | D3915-101 | BASKET LID WELDMENT ASSY |
| 1 | 4 | D2957 | MOUNTING PLATE |
| 2 | 2 | D3915-1 | RIB |
| 3 | 3 | D4016-5 | HINGE HALF, LIGHT LID |
| 4 | 3 | D4019-3 | RIB |
| 5 | 1 | D4035-045 | BASKET LID RIB ASSY, FWD (LIGHT) |
| 6 | 1 | D4035-047 | BASKET LID RIB ASSY, AFT (LIGHT) |
| 7 | 1 | D4056-1 | LABEL PLATE, 350 LIGHT BASKET |



DETAIL C C8-3

DETAIL D B3-3

SECTION B-B B7-3

D3915-101 BASKET LID WELDMENT ASSY

RELEASED
10.08.05

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 4.81 lbs
 - 8) WELD PER DART QSI 004

| | | | |
|------------|----------|--|--------------|
| DESIGN | 1.5 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | DRAWING NO. | REV. C |
| CHECKED | SC | D3915 | SHEET 3 OF 4 |
| MFG. APPR. | SC | TITLE | SCALE |
| APPROVED | SC | LIGHT LID ASSY-LONG BASKET | NTS |
| DE APPR. | SC | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |
| DATE | 10.08.05 | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

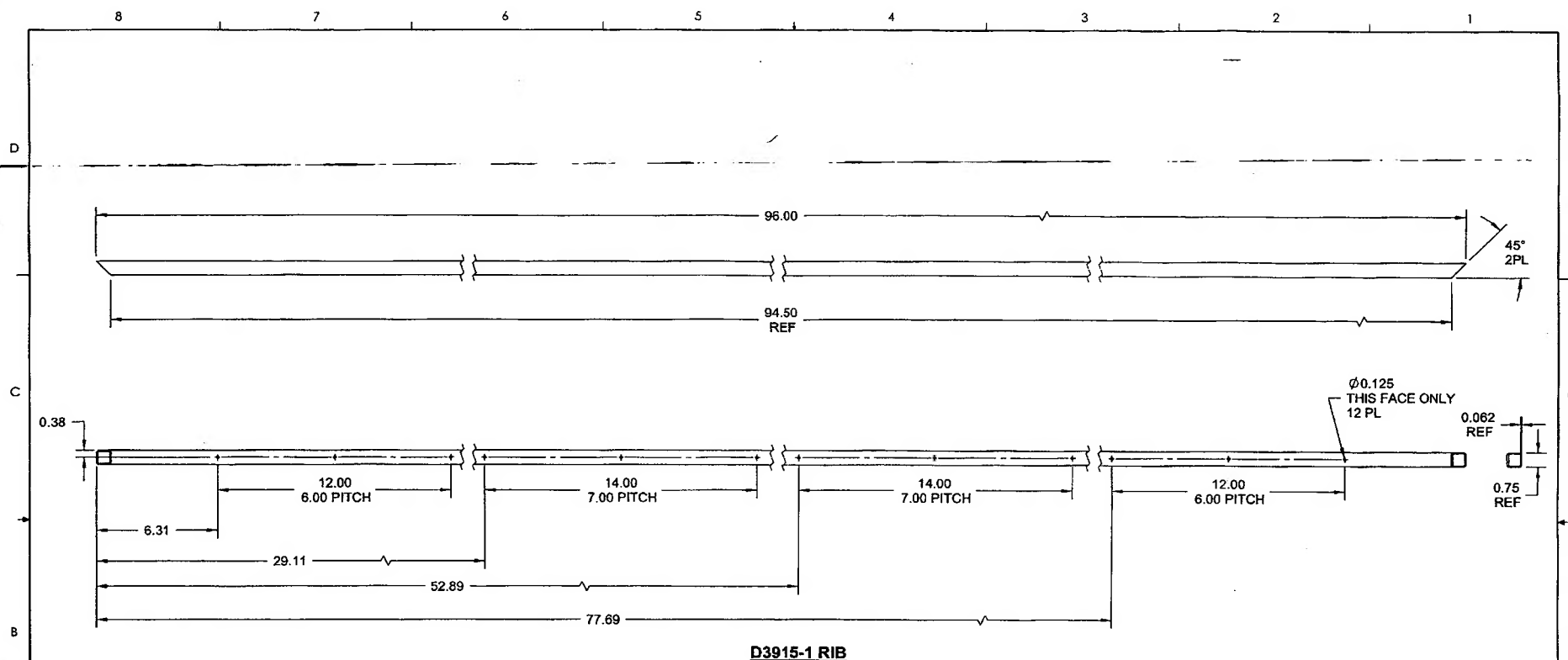
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

75293



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4180)
REF DART SPEC. M6061T6TS0.750W.062
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.49 lbs

RELEASED
(10-01-12 CP)

| | | | |
|--|----------|--|--------------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | SC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | SC | DRAWING NO | REV. C |
| MFG. APPR. | SC | D3915 | SHEET 4 OF 4 |
| APPROVED | SC | TITLE | SCALE |
| DE APPR. | SC | LIGHT LID ASSY-LONG BASKET NTS | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries